

Work Order ID 56424

February 23, 2010 12:51:53 PM



Page 1

Item ID: D6201

Accept



Setup Start



Revision ID:

Stop



Item Name: "T" Extrusion

Start Date: 2/23/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/01/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6201

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11410 a)Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)

f)Material certification required

BS 10-2-23
(12)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Pur 3/2 *(20)*

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February 23, 2010 12:51:53 PM

Page 2

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

Ensure Material certification comply to Dwg D6104

5 colors / 03

20 feet long

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10/3/3/12

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

ME 10-3-4

Picklist Print

February 23, 2010 12:51:52 PM

Page 1

Work Order ID: 56424



Parent Item: D6201



Parent Item Name: "T" Extrusion



Start Date: 2/23/10

Required Date: 3/01/10

Comments: IPP A: 01.05.15 New Issue EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6201P 		Purchased	No			110	f	0.0000	12.0000 			
T Extrusion 4X4X3/8												

Pick 3/2 (20)

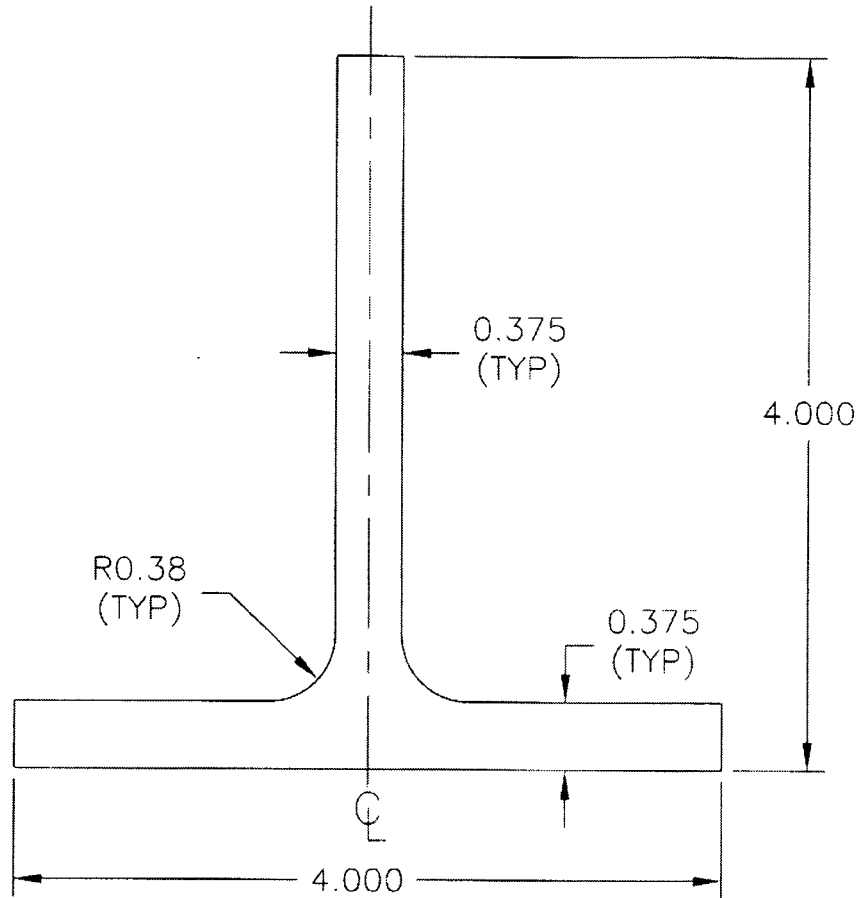


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

REL 01.04.10
01.04.10 #

ulv
56424



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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J6S 5L1



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FAX : 450 377-5696

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FAX : 514 336-4246

ONTARIO : 1 800 867-4248
FAX : 1 866 456-4242

43870
DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir "FER"

VENDU À / SOLD TO:

613-632-5200

613-632-1053

EXPÉDIEZ À / SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

COMMANDE
ORDER

N° 160771

DATE

23/02/10

BON DE LIVRAISON
PACKING SLIP

N°

DATE DE LIVRAISON
DELIVERY DATE

02/03/10

VOTRE N° DE COMMANDE / YOUR PO. N°	VEND. / SALES N°	CODE CLIENT / CUST. CODE	EXPÉDIE PAR / SHIP VIA	TERMES / TERMS	LIBR.	REMARQUES / REMARKS	PAGE N°
P011410	D	DAER		NET 30 JOURS	2R		001

CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PRE PRIS	RE TAX	IMPORTE AMOUNT
M	1		ALUM. TE-BAR 4 X 4 X 3/8 1 X 20' # Heat: C9428142	1.00			
FUL1	1		ENERGETIC SURCHARGE	1.00			

* Unités de mesure : CLB Cent livres / Hundred pounds • CPI Cent pieds / Hundred feet • UN Unit • PI Pied / Foot • PC Pied carré / Square foot

CONDITIONS :

LES MATÉRIAUX LIVRÉS ET FACTURÉS SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MANUFACTURER EST LA MÊME QUE CELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTE IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) JUSQU'À ACCEPTER DE PAYER. TOUT DÉFAUT DE PAYER, À SON CHOIX, DE RÉCLAMER L'OUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU DE REPRISE LE BIEN VENDU. TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUIVANT LA PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU DURÉE NE PEUT ÊTRE RETOURNÉE. AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDISE RETOURNÉE EST SUJÉTTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS:

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. ALL COST MATERIALS ARE AT THE BUYER'S EXPENSE. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAY DUE ACCOUNTS OVER 30 DAYS. ANY DEFAULT IN RESPECTS WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPURCHASE OF THE GOODS SOLD. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANTS THAT HAVE BEEN DAMAGED, OUT OR REOPENED CANNOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

PRÉPARÉ / PREPARED	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR BY	PAR BY	PAR BY	

POIDS TOTAL
TOTAL WEIGHT

269

SOUS-TOTAL
SUB TOTAL

T.P.S.
G.S.T.

T.V.Q.
Q.S.T.

TOTAL

X

A/Y M/M J/D

731240

PO H7S-1 N22214 09/09/09
 SOLD TO PURCHASE ORDER DATE PRINTED

V872002 TER 4.000X4.000X.375
 CUSTOMER PART NUMBER DESCRIPTION

R559583 734563-003 C9428 142 6061-T6
 RELEASE-ITEM LOT ALLOY/TEMPER

8
 10/10/09
 Inspector's Day

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
C9428 142	0001 1	50.1	44.3	14.8	RE 97	N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot	Others
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05	0.15	
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA			

8
 10/09/09



Applicable Requirements:

ASTM-B308-02-STENCILED
 EXCEPT HARDNESS TESTED PER
 C=0.15 AQL SAMPLING PLAN
 ASTM-B221-08 (AMS-QQ-A-200/8)
 AMS-QQ-A-200/16 UNS#96061
 ASME-SB221 1998 SECT II

hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Bill Brennan
 Technical Manager